

Work Order ID 51445

August 24, 2009 2:28:36 PM



Page 1

Item ID: D3637-041
Revision ID: B
Item Name: Bracket Assembly
Start Date: 8/25/09
Required Date: 8/31/09
Reference:

Accept



Setup Start



Stop



Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3637	Rev B
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100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 : Dwg Rev: B : Prog Rev: B : 2-
Deburr if necessary

MA 09 08 24 (12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MA 09 08 24 (12)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 802/09/27

(12) 12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form as per Dwg D3637

SB 09/09/01

12 0

140

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- drill holes as per dwg using DT8979; 12-C'Sink as per Dwg D3637 13-
Install Nut plate as per Dwg D3637

EP 09/09/01 (12)

150

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

27 09/09/01

(12) 0

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Setup Start



Revision ID: B

Stop



Item Name: Bracket Assembly

Start Date: 8/25/09 Start Qty: 12.00



Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location <u>244A</u>	0.00							
	Packaging								
Packaging	Memo	0.00							
170	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

9/9/1 (12X) SD

09/09/01 #J

mf 09-09-01

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Picklist Print

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Page 1

Work Order ID: 51445

Parent Item: D3637-041RevB

Parent Item Name: Bracket Assembly


Comments:

Start Date: 8/25/09


Required Date: 8/31/09

Start Qty: 12.00


Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-3		Purchased	No			100	Each	7,550.000	24.0000			
												
Rivet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7550	
1563	0	
19099	4776	
7681	2774	

M304S14GA		Purchased	No			140	sf	37.4921	1.1368			
												
304SS sheet .080												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	37.4921	
110993Q	37.4921	

MS21059L4		Purchased	No			140	Each	237.0000	12.0000			
												
Nutplate												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	237	
102959	4	
112082	33	
112243	200	

Ep 09/09/01

mm 09 08 24

Ep 09/09/01

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

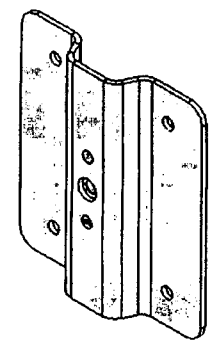
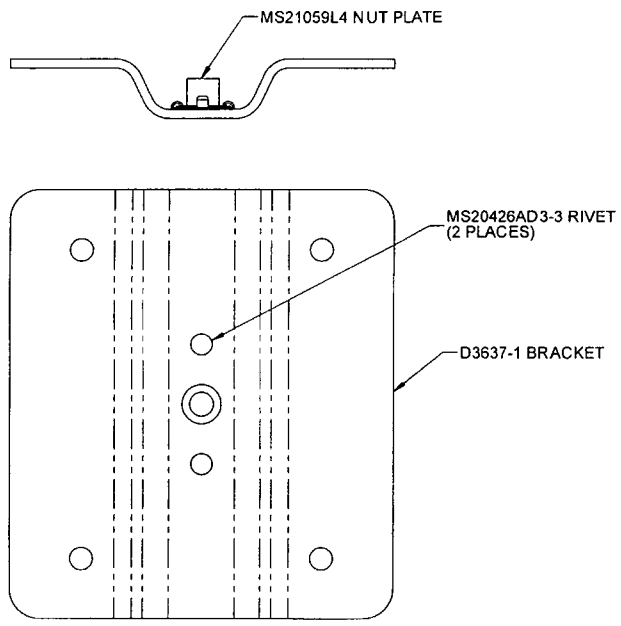
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also
51445



D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

51445

B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE	DRAWING NO.	REV. B
CHECKED	PH	D3637	SHEET 1 OF 3
MFG. APPR.	EP	TITLE	SCALE
APPROVED	EP	BRACKET	1:1
DE APPR.	EP	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.12.18		

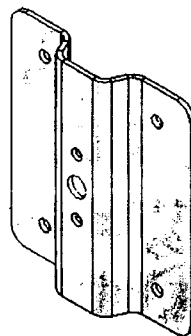
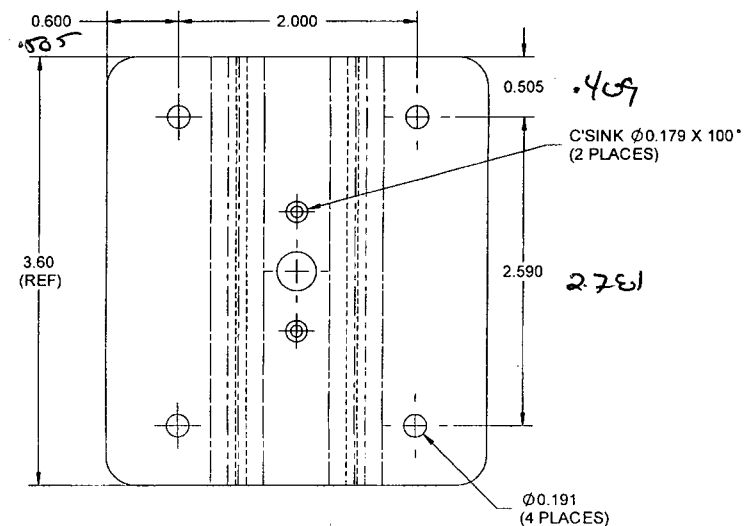
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D3637-1 NOTES:

- DD3077-FNOTES
- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RA	DRAWING NO.	REV. B
MFG. APPR.		D3637	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	1:1
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

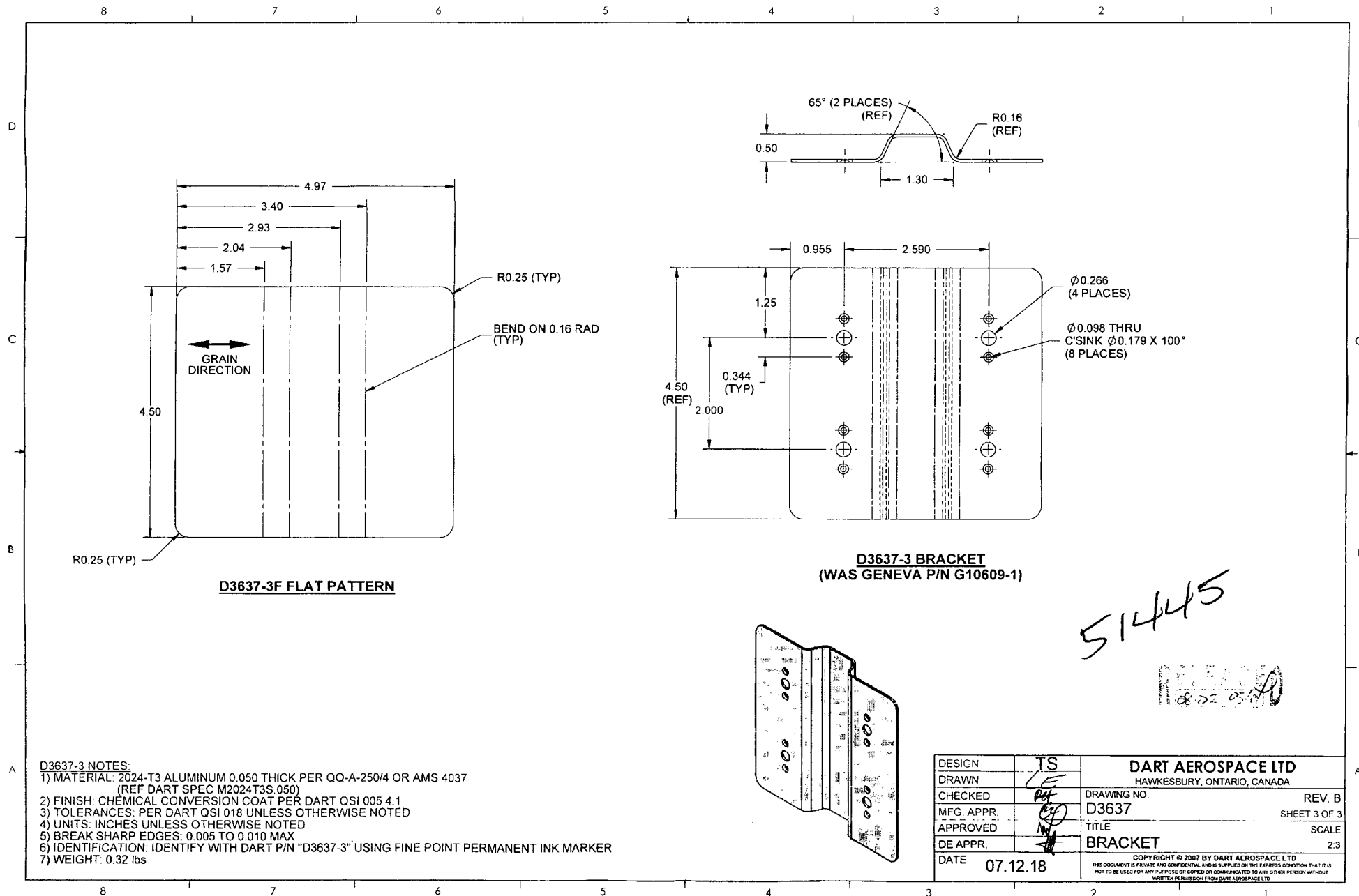
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